May-21-13 3:42:57 PM Item ID: D4048-3 Accept *N900040100* Setup Start **Revision ID:** Item Name: Mounting Lug **Start Date:** 5/21/13 **Start Qty: 12.00** Cust Item ID: Required Date: 6/04/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: MLS Date: 13-55-22 Tooling: **Approvals:** Date: Stop Date: **SPC (Y/N):** Date: Sequence ID/ Operation Set Up/ Accept **Tool ID** Tool # Plan Reject Reject Insp. **Work Center ID** Description Run Hours Number Stamp Code Qty Qty Draw Nbr **Revision Nbr** D4048 Α 100 0.00 *100* Bandsaw 0.00 Memo Jeaspa Bandsaw CUT BLANK 3.700" LONG 110 0.00 13-C.16 12 *110* HAAS 1 Memo HAAS CNC vertical machine #1 MILL AS PER DWG AND FOLIO FA894 DWG RE: 120 QC2- Inspect parts off machine FAI/FAIB 0.00

QC

120

Memo

0.00

Quality Control

13-C.16

Ä

			DQA:	Date:	
ICR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			,
			QA Closed:	Date:	

											QA Closed.	Dati	· · · · · · · · · · · · · · · · · · ·		
Work Orde	∍r•					DISPOSITION				AGAINST DE	DEPARTMENT/PROCESS				
	No			71-		Rework Scrap Use-as-is Work Order Update		Machining Small Fab Thermoforming Finishing		Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root					Descri	ption of work order update	i,	nitial	Act	tion	Sign &				
Cause	Da	ite	Step	Qty	i	or Non-conformance	Chi	ief Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data									• • •						
Equip/Tooling															
Operator											-				
Material															
Setup								ſ							
Other	Ш	i													
Process							٠.	l					·		
Supplier		l					ļ								
Training															
Unapproved				L	<u> </u>	<u> </u>	<u> </u>		<u> </u>				_		
							AUL'	T CATE	GORY						
Landi	ng Gear					General					1	г			
	Bend	-			. -	Bend	-	Grain		-	Ovalized	, -	Pressure/Forced		
·	⊢		t Concer	ntric to	o/s	BOM/Route	-	Hardwa		<u> </u>	Over/Under	F	Temperature/Cure		
	Crac					Broken/Damaged	-	•	on Incomplete	⊢	Part Incorred	⊢	Weld		
	_		Crimped		_	Burrs	-		ions Incomplete/l	<u> </u>	Part Lost/Mi	ssing _	Wrong Stock Pulled		
	Cuff		_			Contamination	\vdash	Mainte			Part Moved				
	\vdash	Trea		T	_	Countersink	\vdash	Mislabe		—	Positioned W				
	—		Strip in	rupe		Cut Too Short	-	Misread	1 ·		Power Loss/S	ourge [Other		
	_ `		Bend		_	Drill Holes	-	Offset	Calibration						
	_		aves in E		''	Drawing Finish	-					•			
		_	ist in Tub		<u> </u>	Folio		Out of Sequence Outside Dimensions							
I	1 1 4 4 4 4	-/	Seni iuk		•	1.000		CACHAC	Directions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

101965

May-21-13 3:42:57 PM

Item ID: D4048-3 Accept *N900040100* Setup Start **Revision ID:** Item Name: Mounting Lug Start Date: 5/21/13 *12* **Start Oty: 12.00 Cust Item ID:** Req'd Qty: 12.00 Required Date: 6/04/13 Customer: Reference: Run **Approvals:** Process Plan: ___ Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Accept Reject Work Center ID Description Run Hours Code Oty Otv 130 QC8- Inspect parts - second check 0.00 *130* 10 13/06/17 იი რ Memo Quality Control 140 Chemical Conversion Coat per QSI005 4.1 0.00 *140* HandFinish 000 Memo Hand Finishing 150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 *150* Powdercoat 0.00Memo ***Mask 0.257" holes and indicated channel prior to powder coat***
POWDER COAT:
Start Time: Powder Coating

M125622

Oven Temperature:_

Finish Time:

Reject Insp. Number Stamp

12 ab 136-19

12x\$ m/f13/06/24

												DQA:	Date	
NCR: Y	es /	/ No				1	WORK ORDER NON-C	10:	NFORI	MANCE / UPD	DATE			
												QA Closed:	Date	
Work Orde	r:					ļ	DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part No							Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Prod. E Machining Small Fab Prod. E Thermoforming Finishing Rec/Store/F Large Fab Composite				Engineering Quality Other
Doot	_				Dose	rinti	on of work order update	لــ	nitial	Acti	ion	Sign &		
Root Cause		Date	Step	Qty	Desc	•	Non-conformance	l	ief Eng	Descri		Date	Verification	QC Inspector
quip/Tooling Operator Material etup Other Process upplier Fraining														
				•			F/	AUL	T CATE	GORY				
Landin	ıg Ge	ar					General							
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend			B B C C C C	end OM/Route roken/Damaged urrs ontamination ountersink ut Too Short Orill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset		Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
		orque W			n [_	Prawing		-1	Calibration	•			
	_	urning Se Vave/Twi				_	inish olio	Out of Sequence Outside Dimensions						

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Work Order ID 101965

May-21-13 3:42:57 PM

101965

Item ID: Revision ID:	D4048-3		1	Accept	*N900	1040	100	*	Setup	Start	*N:	S1*	
Item Name:	Mounting Lug				.					Stop	*N!	S2*	
Start Date: Required Date:	5/21/13	Start Qty: 12.00 Req'd Qty: 12.00	*12*		Cust Item								
Reference:	. 0/04/13	Req u Qiy: 12.00	*12*		Customer:								
Approvals:	Process Pla	n:	Date:	Tooling:	; D	ate:	_	F		Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	D)ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	-
160		QC3- Inspect Part Finish		ф .00						r			
160 QC		Memo		0.00		. *		12	X	(<u> </u>	H	3/06/2	24
Quality Control													
170		Identify as per dwg & Stor	ck Location: ST OF S	0.00	٠,								
170								DX	-	٠		\sim	
Packaging		Memo		0.00	1		-					OF	
Packaging					1								
180		0001 F11	W 101 P1							10	1 /	- 10	
		QC21- Final Inspection -	Work Order Release	0.00	•				,	13/	612	74/	
120		Memo		0.00			-		/				
Quality Control		MEHIO		0.00								_	
											•		
					·					1. 1	10 01	11.	

NCR:	Yes	/	No

DQA: _____Date: ____

NCR: Ye	es / No				WORK ORDER NON-	CONFO	RIVIANCE / UP	'DATE	QA Closed:	Date	e:
Work Order	}.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is] _{The}	Skid-tube Machining rmoforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0				Work Order Update		Large Fab	Composite	Nec/Stol	Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty	- 1	or Non-conformance	Chief Er	g Desc	cription	Date	Verification	QC Inspector
oc/Data											
quip/Tooling											
perator		1									
Naterial	_										
etup	_										
)ther	_								:		:
rocess	4										
upplier	_								:		
raining	4										
Inapproved							50001				
		-				AULT CAT	EGORY		····		
Landin					General			_	Ovalized	Г	Pressure/Forced
-	Bending			,,	Bend	Grain		-	4	+=1=====	
-		Not Conce	ntric to (^{D/S} -	BOM/Route	Hard		-	Over/Under	<u> </u>	Temperature/Cure Weld
-	Cracks			<u> </u>	Broken/Damaged	⊢ ⊣ `	ction Incomplete	// / / / / / / / / / / / / / / / / / /	Part Incorred	—	_
-	_	I/Crimped		-	Burrs	⊢ ⊣	ctions Incomplete/	Unclear	Part Lost/Mi	issing [Wrong Stock Pulled
	Cuffs	_		 	Contamination	→	tenance	<u> </u>	Part Moved	Mana	
-	Heat Tr			\vdash	Countersink	Misla		<u> </u>	Positioned V	· ·	Other
-	-	on Strip in	Tube	<u> </u>	Cut Too Short	Misre		L_	Power Loss/	ourge	Toruer
-	Ripples			<u> </u>	Drill Holes	Offse					
·		Waves in E		י	Drawing	\mapsto	f Calibration				
ļ-		Sequence		<u> </u>	Finish		f Sequence				
Wave/Twist in Tube				l	Folio	Outsi	de Dimensions				

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Picklist Print

May-21-13 3:43:00 PM

Work Order ID: 101965

Parent Item:

D4048-3

101965 *D4048-3*

Parent Item Name: Mounting Lug

Start Date: 5/21/13

Required Date: 6/04/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A NEW ISSUE 10-01-26 JLM VERIFIED BY:EC

IPP Rev:B

as per dwg revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X04.00 0		Purchased	No			100	f	17.0000	0.308	3.890526	·		
M6061T6	B1 500	X04 00)೧			ļ ļ			**		٧/.	3-6-9	
				Location		Loc	<u>Oty</u>	Loc Code					
				MAT009		į	17						
				11	13797		5			3-94-11			
				11	19231		12		_				

										DQA:	Date:		
NCR: Y	es / No				WORK ORDER NON-	COI	NFORI	MANCE / UPDATE	_	QA Closed:	Date:	•	
Work Orde	ŕ:		·		DISPOSITION			AGAINS	T DE	PARTMENT	ARTMENT/PROCESS		
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update Skid-tube Machining Thermoforming Large Fab			Machining Small Fall noforming Finishing	Small Fab Prod. Eng. Coor. Quality Finishing Rec/Store/Packaging Other			· —	
Root				Descr	iption of work order update	T	Initial	Action		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector	
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved													
					F	AUI	T CATE	GORY					
Landir	ng Gear				General		Grain			Ovalized		Pressure/Forced	
ŀ	Bending	ਤ Not Conce	ntric to	0/5	Bend BOM/Route	\vdash	Grain Hardwa	aro.	\vdash	Over/Under	tolerance	Temperature/Cure	
ŀ	Cracks	NOC CORCE	THE LO	o″³ -	Broken/Damaged	-	-1	ion Incomplete	\vdash	Part Incorre	├	Weld	
<u> </u>		d/Crimped		H	Burrs		4	tions Incomplete/Unclear		Part Lost/M	_	Wrong Stock Pulled	
	Cuffs				Contamination		1	enance		Part Moved		•	
	Heat Tr	eat			Countersink	Г	Mislabe	eled		Positioned V	Vrong	_	
	├ ─┤			Cut Too Short		Misrea	d		Power Loss/	Surge	Other		
Ī	Ripples	in Bend			Drill Holes		Offset						
Ī	Torque	Waves in	Extrusio	n [Drawing		Out of	Calibration					
	Turning	Sequence	:		Finish		Out of	Sequence					
	Wave/1	wist in Tu	be		Folio	Outside Dimensions							

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DART AEROSPACE LTD	Work Order:	101965
Description: Mounting Lug	Part Number:	D4048-3
Inspection Dwg: D4048 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.115	+/-0.010	117		<u> </u>	PP. 02 A/	7.
R0.13	+/-0.030	. 128				<u></u>
1.00	+/-0.030	1.002				
R0.063	+/-0.010	. 063				
0.050 x 45°	+/-0.010 x +/-0.5°	-040×+	6			
0.300	+/-0.010	.304				
0.400	+0.000/-0.015	. 397				, , , , , , , , , , , , , , , , , , ,
1.158	+0.015/-0.000	1.160				
8.5°	. +/-0.5°	8.50				
0.875	+/-0.010	. 883				
0.770	+/-0.010	· 768				
1.00	+/-0.030	1.00/				· · · · · · · · · · · · · · · · · · ·
3.75	+/-0.030	3.753				
Ø0 .257	+0.006/-0.001	. 257				
3.000	+/-0.010	2,999				
1.500	+/-0.010	1.499		-		
0.38	+/-0.030	, 374		_		
2.00	<u>+/-</u> 0.030	-1.999-	. /	/		
Ø0.63	+/-0.030	.626		_		
60°	+/-0.5°	600		<i></i>		
Ø0.257	+0.006/-0.001	. 287				
1.500	+/-0.010	1.500		_		
0.60	+/-0.030	- 579				
0.550	+/-0.010	.549				
1.75	+/-0.030	1.747				· · · · · · · · · · · · · · · · · · ·
0.63	+/-0.030	.624				
	L CAG					

Measured by:	04 8-89	Audited by:	PD	Preliminary Approval:	
Date:		Date:	13/66/17	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.06.08	New Issue	KJ OK)	- N
				1 1 1 2 2 2

